

Date: Tuesday, 9/4/2007 11:30:27 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : HORIZONTAL TUBE
Job Number : 34421	
Estimate Number : 12313	
P.O. Number : <i>N/A</i>	Part Number : D34737
This Issue : 9/4/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3473 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL / MED FAB	Drawing Revision : B
Previous Run : 28588	Material : <i>N/A</i>
Written By : _____	Due Date : 10/4/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i> 07.09.04	
Comment : Est Rev:A New Issue 06-03-02 JLM	
Est Rev:B As per Rev B 06-05-24 JLM	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
-----	-----------	---------------------



Comment: Qty.: 0.6305 sf(s)/Unit Total : 3.7832 sf(s)  
 304/316 0.018 SHEET  
 Batch: *1105490*

*SAD 07/09/04*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET  
 Cut as per Dwg D3473  
 Dwg Rev: *B*  
 Prog Rev: *B*

*SAD 07/09/04*

*6*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/09/04*

*6*

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

*En 07/09/05*

*count 26*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Debur if necessary.

2-Roll & Bead as per Dwg D3473

3-Spot weld as per Dwg D3473

*mf*

*07-10-25*

*[Signature]*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/10/16  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 9/4/2007 11:30:27 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HORIZONTAL TUBE

Job Number: 34421

Part Number: D34737

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC11

VISUAL INSPECTION OF SPOT WELDING



Comment: VISUAL INSPECTION OF SPOT WELDING

SB 07-10-26 (6)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 07-10-26 (6)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

mf 07-10-26

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

SB 07-10-26 (6)

Job Completion



U 07-10-26

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

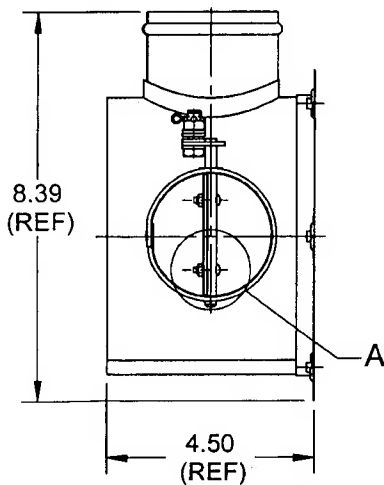
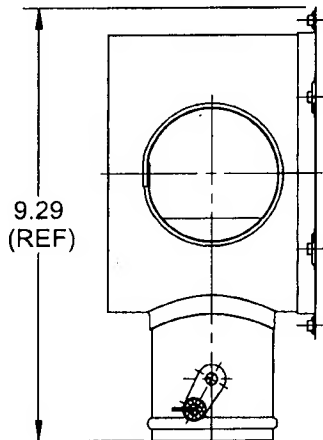
**NOTE:** Date & initial all entries



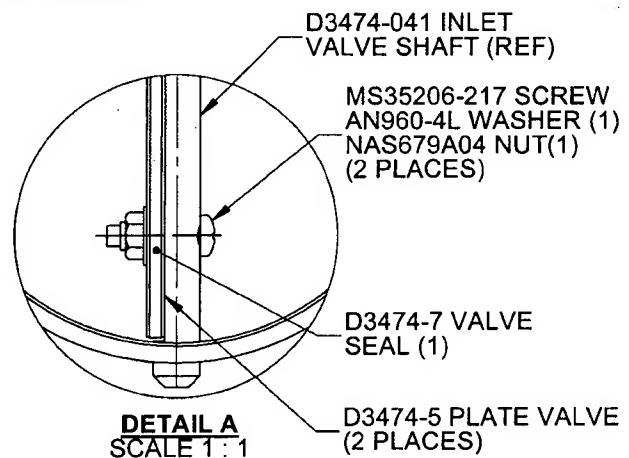
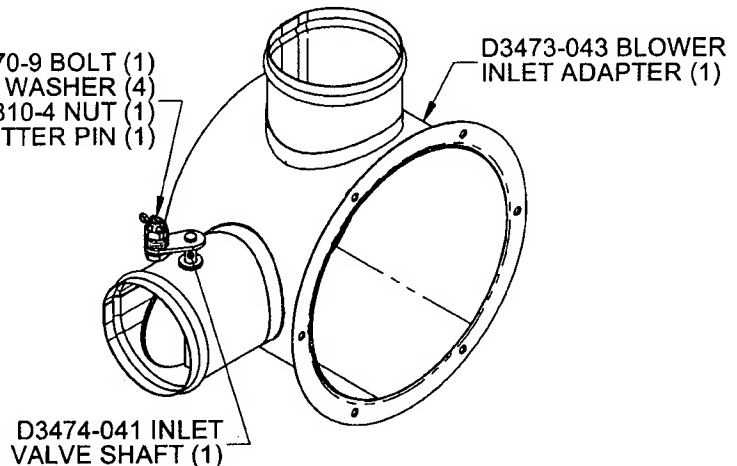


DESIGN 13	DRAWN BY 13	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. <b>D3473</b>	REV. B SHEET 1 OF 7
DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4
A	06.02.07	NEW ISSUE	
B	06.05.16	D3473-5F/-7F: 9.750 & 8.810 WERE 9.60 & 8.60	

RELEASED  
06-05-16 H



D3470-9 BOLT (1)  
AN960-416 WASHER (4)  
AN310-4 NUT (1)  
MS24665-153 COTTER PIN (1)



### **D3473-041 BLOWER INLET ADAPTER**

#### **NOTES:**

- 1) IDENTIFY WITH DART P/N D3473-041 USING FINE POINT PERMANENT INK MARKER
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3473-041	BLOWER INLET ADAPTER
1	D3470-9	BOLT
1	D3471-043	BLOWER INLET WELDMENT
1	D3474-041	INLET VALVE SHAFT
2	D3474-5	BUTTERFLY VALVE
1	D3474-7	BUTTERFLY VALVE SEAL
1	AN310-4	NUT
2	AN960-4L	WASHER
4	AN960-416	WASHER
1	MS24665-153	COTTER PIN
2	MS35206-217	SCREW
2	NAS679-A04	NUT

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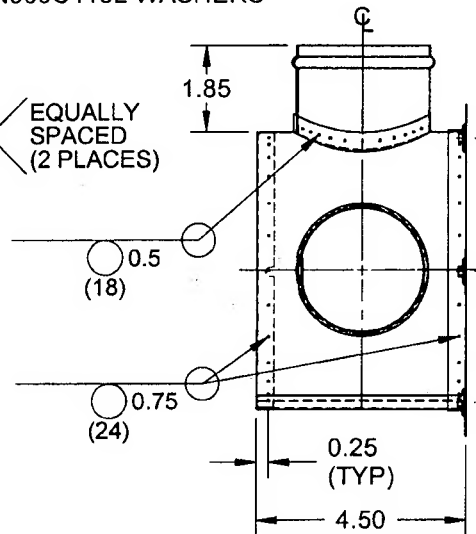
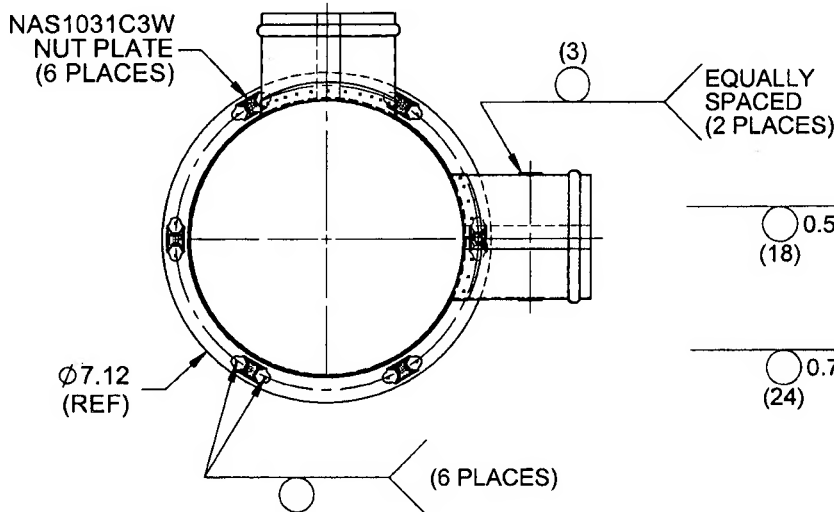
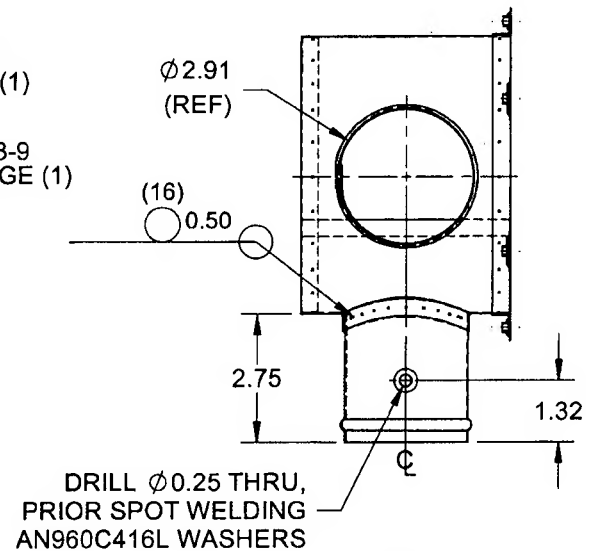
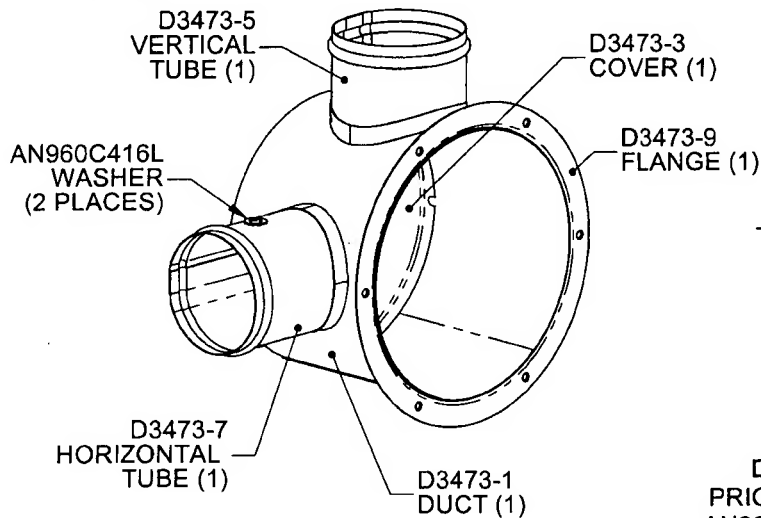
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

RELEASED  
06.05.16



### D3473-043 BLOWER INLET WELDMENT

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

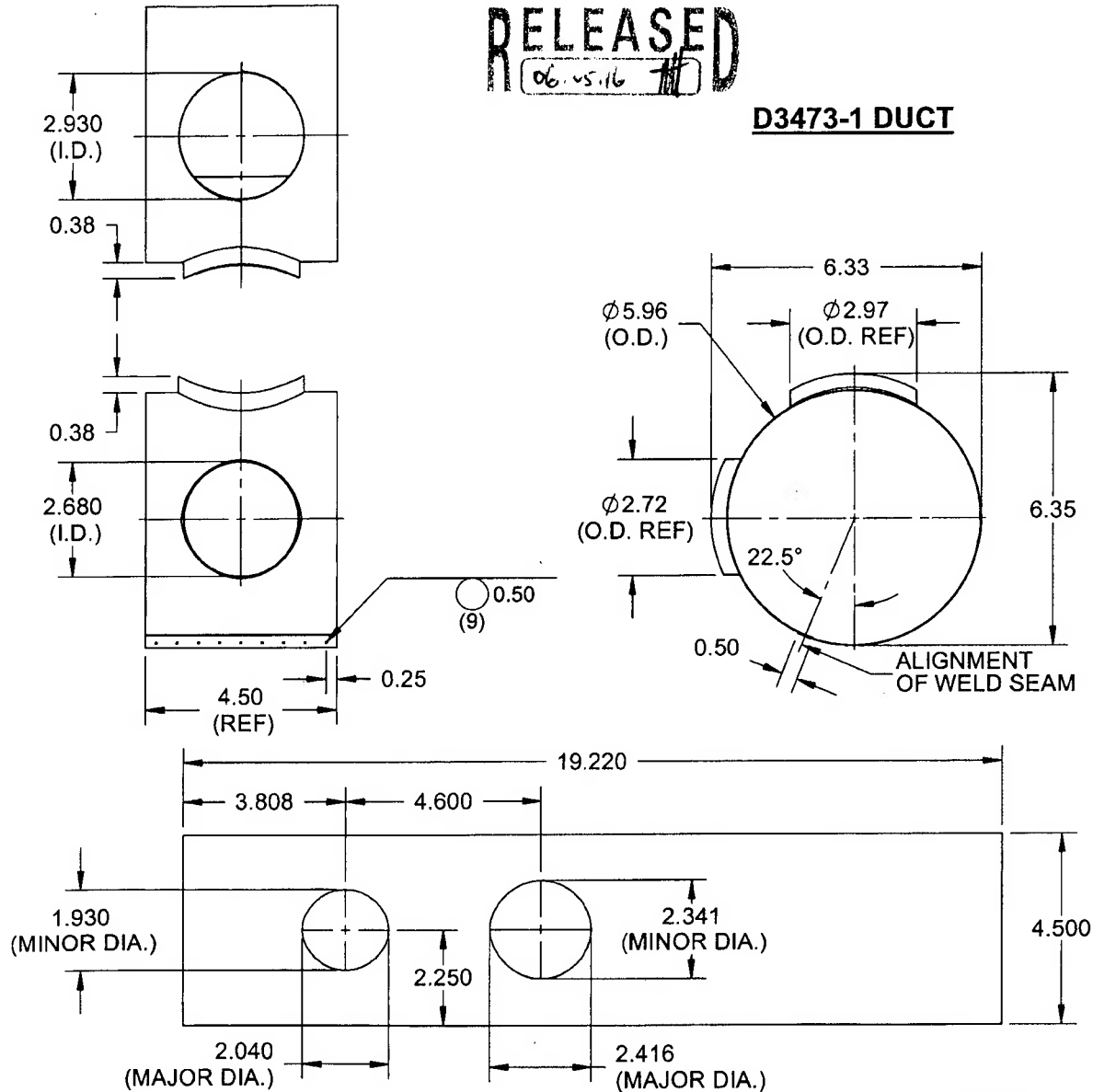
QTY -041	P/N	DESCRIPTION
X	D3473-043	BLOWER INLET WELDMENT
1	D3473-1	DUCT
1	D3473-3	COVER
1	D3473-5	VERTICAL TUBE
1	D3473-7	HORIZONTAL TUBE
1	D3473-9	FLANGE
2	AN960C416L	WASHER
6	NAS1031C3W	NUT PLATE

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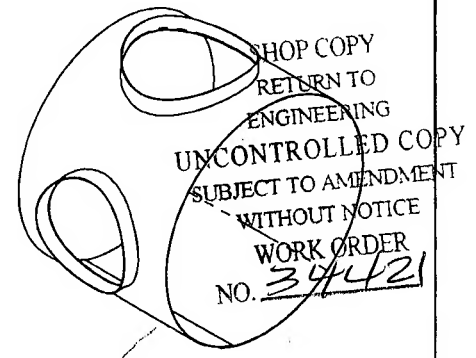
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:4

**RELEASED**  
*[Stamp: 06.05.16]***D3473-1 DUCT****D3473-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED)  
2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010



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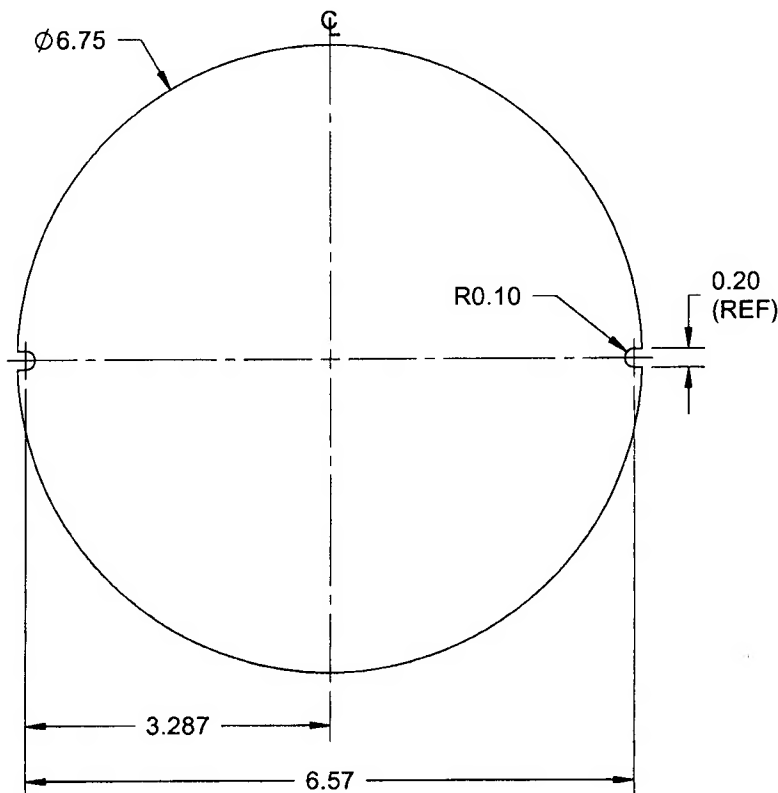
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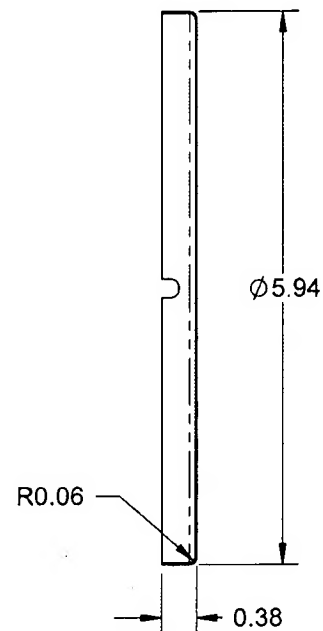


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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

RELEASED  
06-05-16 *JB*



**D3473-3F COVER FLAT PATTERN**



**D3473-3 COVER**

**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)
- 2) PART IS SYMMETRICAL ABOUT CENTERLINE
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

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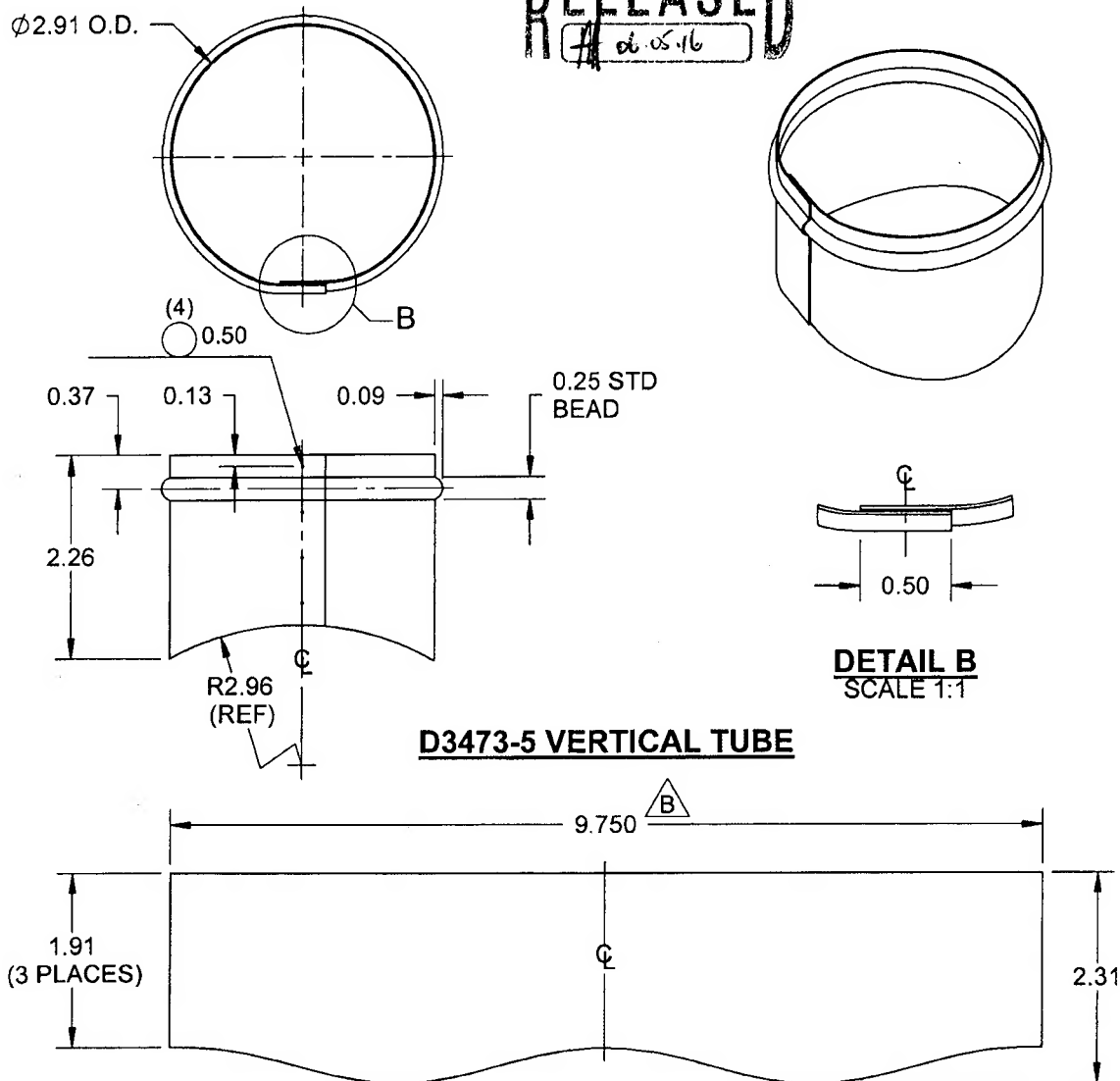
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DATE 06.05.16		TITLE BLOWER INLET ADAPTER	SCALE 1:2

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**D3473-5 VERTICAL TUBE**

**DETAIL B**  
SCALE 1:1

**D3473-5F VERTICAL TUBE FLAT PATTERN**

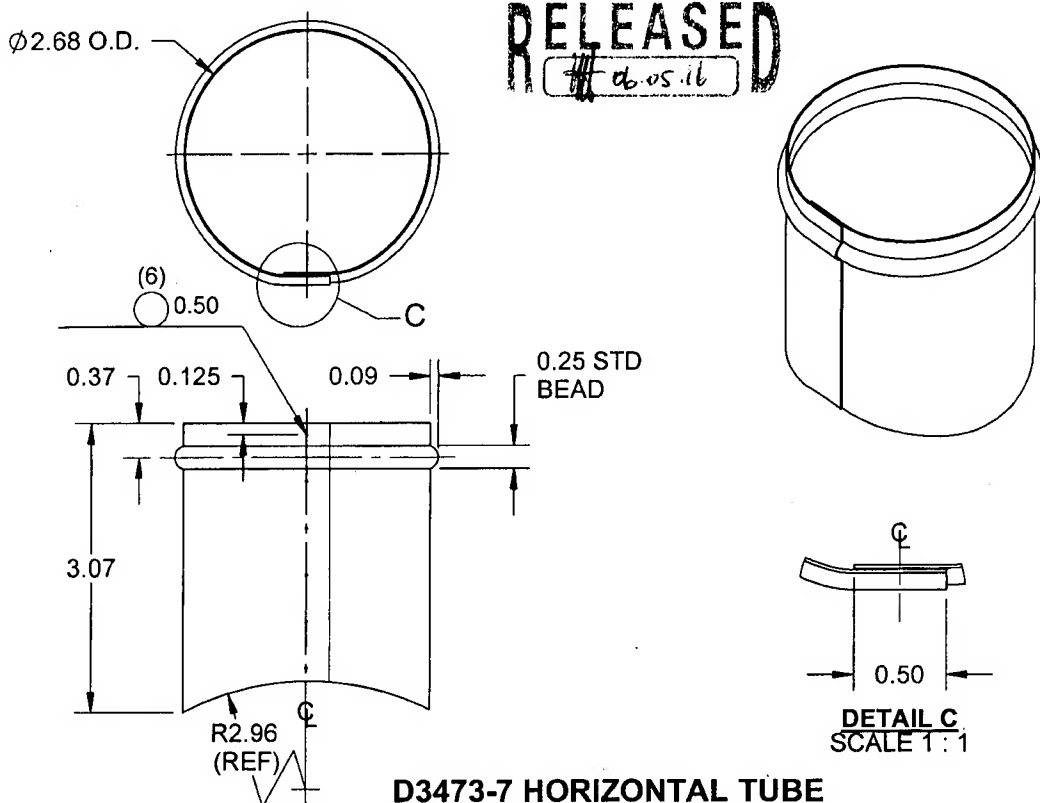
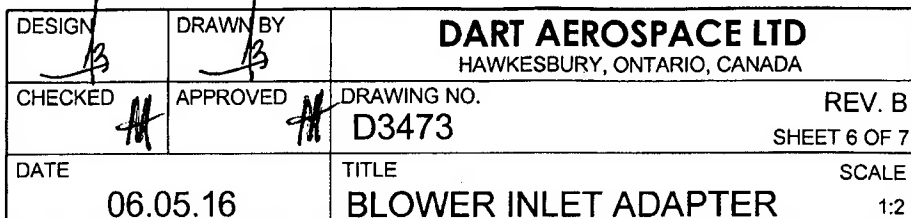
**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH 26 GAUGE SS (0.018 THICK)
- 2) SPOT WELD PER DART QSI 004
- 3) FINISH: NONE
- 4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES
- 7) BREAK ALL SHARP EDGES 0.005 TO 0.010

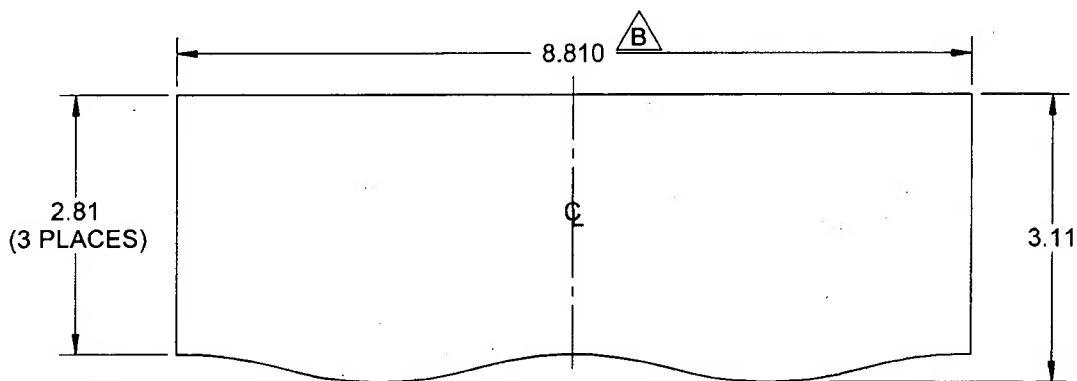
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### D3473-7 HORIZONTAL TUBE



### **D3473-7F HORIZONTAL TUBE FLAT PATTERN**

1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
2) SPOT WELD PER DART QSI 004  
3) FINISH: NONE  
4) FLAT PATTERN IS SYMMETRICAL ABOUT CENTERLINE  
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
6) ALL DIMENSIONS ARE IN INCHES  
7) BREAK ALL SHARP EDGES 0.005 TO 0.010

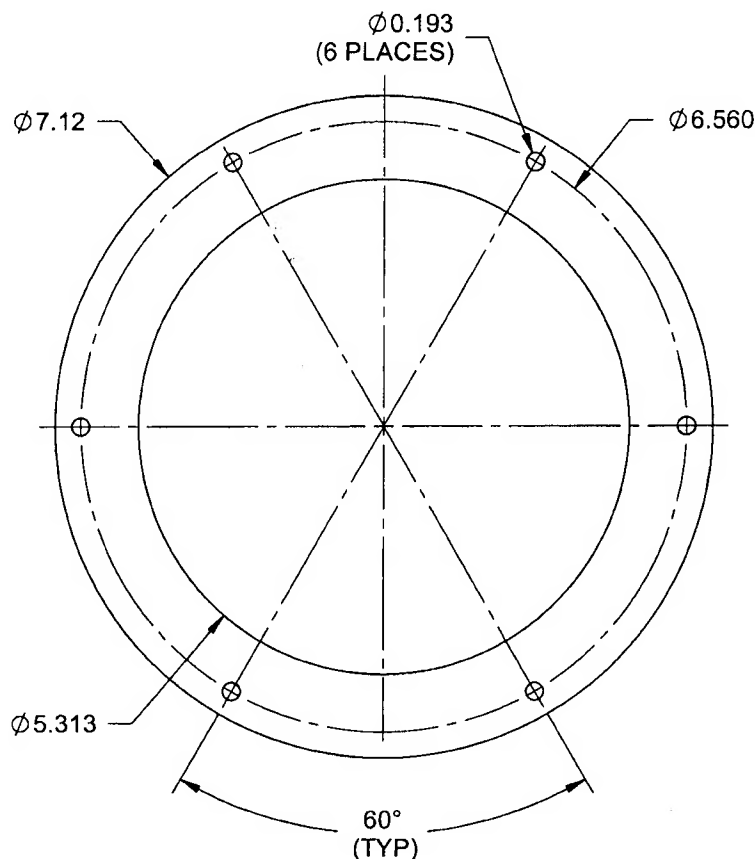
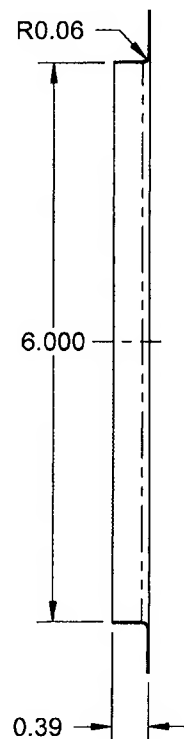
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DATE <b>06.05.16</b>		TITLE <b>BLOWER INLET ADAPTER</b>	SCALE 1:2

**RELEASED**  
*[Stamp]***D3473-9F FLANGE FLAT PATTERN****D3473-9 FLANGE BENDING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH ENGINEERING 26 GAUGE SS (0.018 THICK) (REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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# SPOT WELD TEST RECORD

AMS-W-6858A

CLASS 'C'

TEST NO#: 33

EMPLOYEE: Meloni Fauter

PART NUMBER: D3473-7

JOB NUMBER: 34421

MATERIAL TYPE: 304L

MATERIAL THICKNESS: 0.18

GROUP SPECIFICATION



Group 1: Aluminum & magnesium



Group 2: Iron; nickel; cobalt



Group 3: Titanium, SS

## TEST RESULTS

	PASS	FAIL
VISUAL:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PENETRATION:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]
PULL STRENGTH:	[ <input checked="" type="checkbox"/> ]	[ <input type="checkbox"/> ]

PSI Reading: \_\_\_\_\_

Qualified in accordance with standard AMS-W-6858A and QSI 004 (ref: 4.3)

DATE OF TEST COUPON: 07/10/26

QUALIFIER: SB